

Date: Monday, 22/10/2007 2:17:19 PM  
User: Linda Lacelle

## Process Sheet

H. Split

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 35297-13  
Estimate Number : 12883  
P.O. Number :  
This Issue : 22/10/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : SMALL /MED FAB  
Previous Run : 35031

Drawing Name : ARM

Part Number : D3560043  
Drawing Number : D3560 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : C  
Material :  
Due Date : 29/10/2007

Qty: 14 Um: Each

Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07.05.24 EC  
Est Rev B ECN 987 07.10.09 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total: 19.0365 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: P106182

JNL 07/11/30

(14)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

JNL 07/11/30

(14)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: A &amp; Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

JF 07/12/07

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 07/12/07

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JF 07/12/11 (14)





Date: Monday, 22/10/2007 2:17:19 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35297

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)  
PLATE

B35331 B42279

SP 08.09.30 (3X)  
08-07-10 SP (4X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

### STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) SP SP
- 2- set up bracket and arm on jig SP SP
- 3- preheat bracket and arm with torch SP SP
- 4- clean before welding with brush SP SP
- 5- set up machine to 135 amps SP SP
- 6- weld across bottom and top ends SP SP
- 7- reheat with torch ( ) SP SP
- 8- on one side weld from bottom to top half way SP SP
- 9- same for other side (half way) SP SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP SP
- 11- same for remaining side (ease off pedal near end) SP SP

SP 08.09.30 (3X)  
08-07-10 SP (4X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0810-01 (1) (PTD)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-30 (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-10-02 (XX)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/02 (1)





Date: Monday, 22/10/2007 2:17:19 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35297

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Spacer

batch: B37113

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B2

8/10/02

1+

50

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

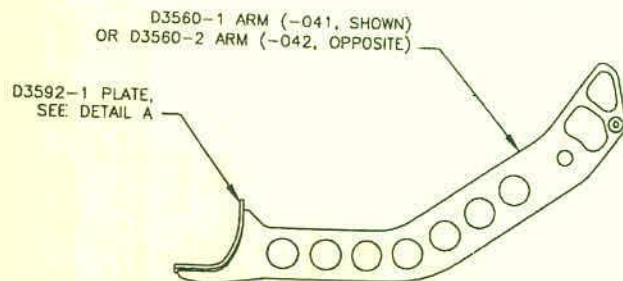
08/10/03

Job Completion

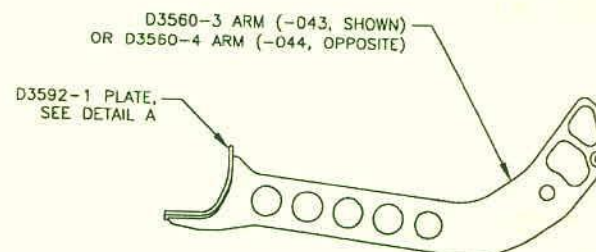


u 08.1003

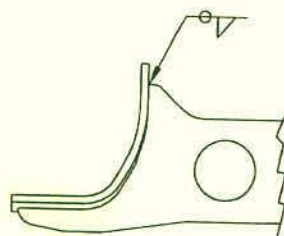
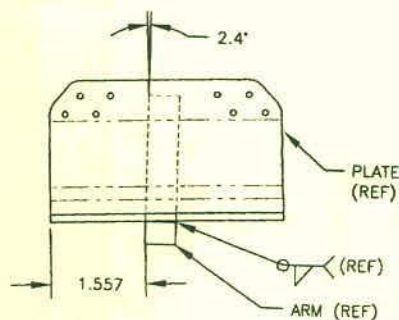




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



**DETAIL A**  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19  
**UNDER REVIEW**  
07.10.22 DC

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

C	07.06.19	REMOVE POWDER COAT	
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS	
A	06.09.25	NEW ISSUE	
DESIGN	9P	DRAWN BY	9P
CHECKED	H	APPROVED	H
DATE	07.06.19	DRAWING NO.	D3560
		TITLE	ARM WELDMENT
		SCALE	1:4

**DART** DART AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

REV. C  
SHEET 1 OF 3







<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 35297
<b>Description:</b> Arm		<b>Part Number:</b> D3560-3
<b>Inspection Dwg:</b> D3560	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

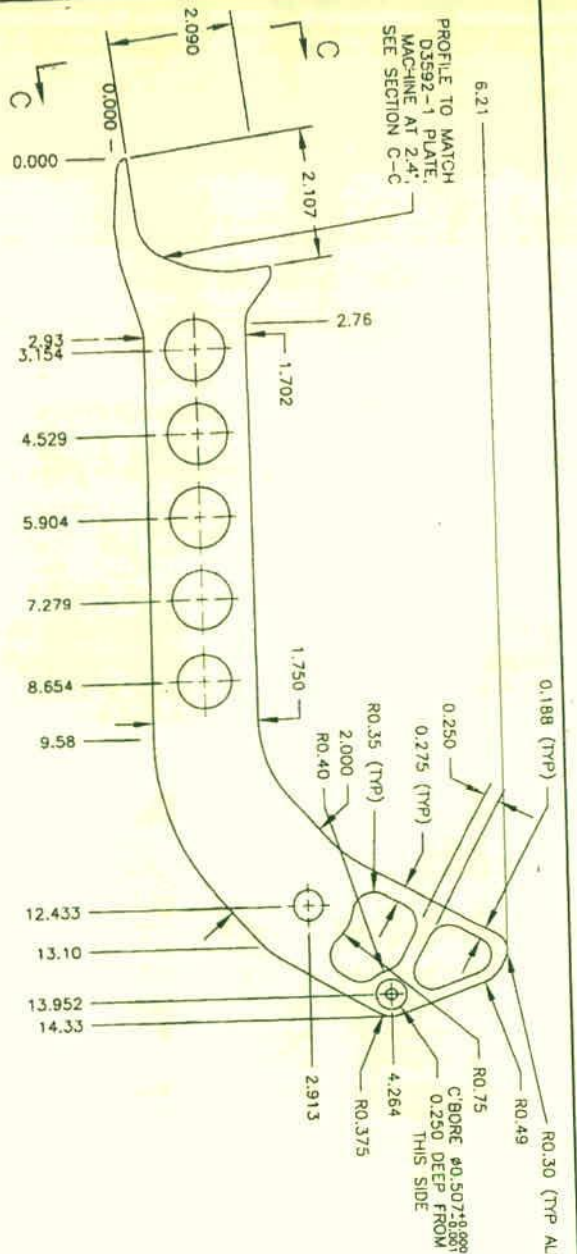
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.196	+0.005/-0.001	.196	✓			
Ø1.000	+0.010/-0.001	1.000	✓			
Ø0.900	+0.010/-0.001	.899	✓			
0.500	+/-0.010	.502	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.276	✓			
0.188	+/-0.010	.189	✓			
2.000	+/-0.010	2.002	✓			
1.750	+/-0.010	1.752	✓			
1.702	+/-0.010	1.704	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.391	✓			
0.250 Deep	+/-0.010	.250	✓			

<b>Measured by:</b> J.F.	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/12/07	<b>Date:</b> 07/12/07	<b>Date:</b>	N/A

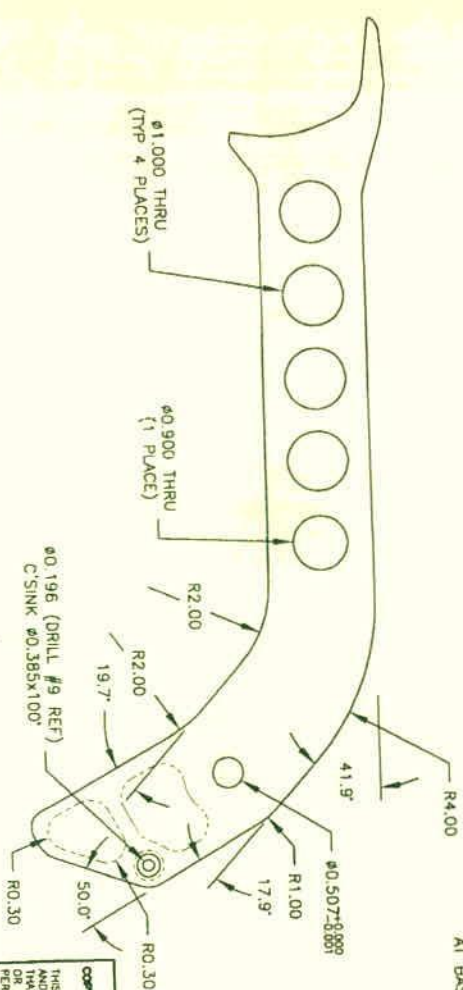
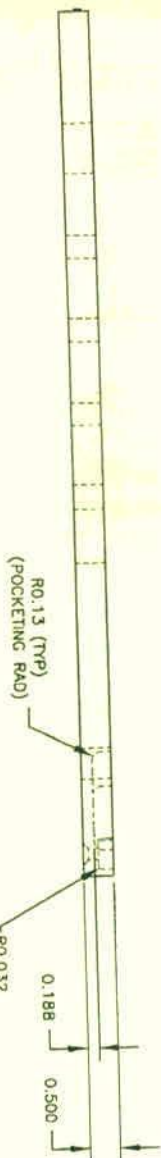
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	



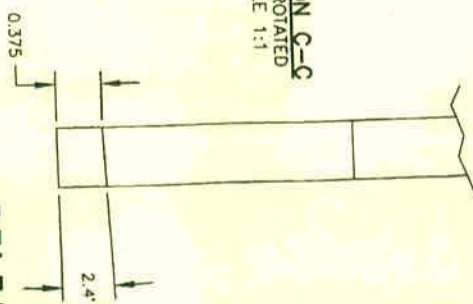




- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(00-A-200/8 OR 00-A-250/11, REF DART SPEC.  
M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



4635097



RELEASED

DESIGN		DRAWN BY		DART		DART AEROSPACE LTD.	
47		47		DART		DART AEROSPACE LTD.	
CHECKED		APPROVED		DRAWING NO.		SHEET 3 OF 3	
DATE		DATE		TITLE		SCALE	
07.06.19		07.06.19		ARM WELDMENT		1:2	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED TO ANY OTHER PROJECT WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-043 PAR #: N/A Fault Category: Eng Bug NCR: Yes No DQA: A Date: 08/10/06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>35297</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-10-01</u>	<u>7.0</u>	<u>2 parts were found with cracks.</u> <u>R.C: Design &amp; tricky process.</u>	<u>[Signature]</u>	<u>Scrap &amp; destroy.</u> <u>SEE CR 08-026</u>	<u>SAD</u> <u>08/10/01</u>	<u>[Signature]</u> <u>08-10-01</u>	<u>[Signature]</u> <u>08-10-01</u>	<u>[Signature]</u> <u>08-10-01</u>

NOTE: Date & initial all entries

100-100

100

100-100  
100-100  
100-100  
100-100

100-100

100-100

100-100

100-100

100-100